Work Order ID 111328

January-13-14 10:17:56 AM

111328

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fwd, Center Ceiling Panel

Start Date: 1/13/14 **Start Qty:** 1.00 *1*

Required Date: 1/27/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLJ **Date:** 14-01-13 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4634	**Revision Nbr** ~~PD2~~ E DL								
100	HAND FINISHING THERMOFORMING	0.00				x 1			DL 14/01/3
100 Thermoform	**Memo** Cut Blanks	0.00				x1			DL 14/01/12
Thermoforming Machine									
105	Dry Material	0.00				x1			DL 14/01/31
105 HandThermo	**Memo** Dry Sheet as per QSI022 POLYCARBONATE	0.00				x 1			DL 14/01/12
Hand Finishing Thermoforming	Temp: 345° F								
	Time IN: 5:00 pm	14/01/11 14/01/30							
	Time OUT: 6:00 am	14/01/12 14/01/31							

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Fwd, Center Ceiling Panel

Start Date: 1/13/14 **Start Qty:** 1.00 *1*
Required Date: 1/27/14 **Req'd Qty:** 1.00 *1*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110		0.00							WK 14/01/31
110	THERMOFORMING MACHINE					X1	X1		DH 14/01/12
Thermoform	**Memo**	0.00							
Thermoforming Machine	Thermoform as per Dwg. D4634-1 and Folio FTA144								
	Dwg. Rev. E								
	Folio Rev. B								
	Visually inspect for proper formation and texture								
130		0.00							P10 → BW 14/02/02
130	HAND FINISHING THERMOFORMING					X1	X1		
Thermoform	**Memo**	0.00							
Thermoforming Machine	Trim to Finished Dimensions								
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
140						1			SAD 14/02/11
QC	**Memo**	0.00							
Quality Control									

DQA: [signature] Date: 14-2-24

QA Closed: [signature] Date: 14-2-14

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: 111328

Part No. D4634-1

NCR No. 14-3532

DISPOSITION

Rework	☐
Scrap	☒
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☒	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐	14/02/24	120	+1	Found when Filing & measuring out inspection sheet that hole @ 25.78 was Drilled @ 27.250. ~~Re. Operator Error~~ RC. Tooling.	[signature] Jan 2014	SCRAP + Destroy ~~No Replace~~ Replace	SMT 14/2/14	SMT 14/2/10	DAS 16 9-89 14/02/24
Doc/Data	☐									
Equip/Tooling	☒									
Handling/Pre	☐									
Material	☐									
Operator	☒									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐	Bending
☐	Centre Not Concentric
☐	Cracks
☐	Crimp/Kink/Ripple/Wave
☐	Cuffs
☐	Crushing
☐	Heat Treat
☐	Inspection Strip in Tube
☐	Marks/Chatter
☐	Turning Sequence
☐	Wave/Twist in Tube

General

☐	Bend
☐	BOM/Route
☐	Broken/Damage/Defect
☐	Burrs
☐	Contamination
☐	Countersink
☐	Cut Too Short
☐	Drawing
☐	Drill Holes
☐	Finish
☐	Fit/Function
☐	Folio/Program
☐	Grain
☐	Hardware
☐	Inspection Incomplete/Unqualified
☐	Instructions Incomplete/Unclear
☐	Misaligned/off center
☐	Mislabeled
☐	Misread
☐	Off-set
☐	Out of Calibration
☐	Out of Sequence
☐	Outside Dimensions
☐	Over/Under tolerance
☐	Part Incorrect
☐	Part Lost/Missing
☐	Part Moved
☐	Positioned Wrong
☐	Power Loss/Surge
☐	Pressure/Forced
☐	Set-up
☐	Temperature/Cure
☐	Weld
☐	Wrong Stock Pulled
☒	Other

Lack of tooling

Work Order ID 111328

January-13-14 10:17:56 AM

111328

Item ID: D4634-1 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Fwd, Center Ceiling Panel

Start Date: 1/13/14 **Start Qty:** 1.00 *1*

Required Date: 1/27/14 **Req'd Qty:** 1.00 *1*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00	DAS 16 9-89						
150			14/02/11						
QC	**Memo**	0.00							
Quality Control									
160		0.00							
160	Packaging					(1)	SAD	14/02/11	
Packaging	**Memo**	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170						MCJ		14-02-11	
QC	**Memo**	0.00							
Quality Control									

MF 14-2-11

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐				
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐				
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐				
Large Fab ☐	Composite ☐	Supplier ☐	☐				

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Picklist Print

January-13-14 10:17:59 AM

Work Order ID: 111328 *111328*

Parent Item: D4634-1 *D4634-1*

Parent Item Name: Fwd, Center Ceiling Panel

Start Date: 1/13/14 **Required Date:** 1/27/14

Start Qty: 1.00 **Required Qty:** 1.00

Comments: IPP Rev.A New Issue 12/05/07 DL VERIFIED BY:JLM IPP Rev. B Dwg. Update 13/07/09 DL verf:DD IPP Rev C Dwg Update, Material Change 13/12/18 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	1,861.260	12.93	16			
MLEXS.093-F6006-07									**				
GE PLASTICS LEXAN SHEET													

Location	Loc Qty	Loc Code
MAT023	1861.26	
114459	229.26	
123105	38	
124501	1594	

16 sq ft

16 sq ft.

4/02/03

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- ☐ Rework
- ☐ Scrap
- ☐ Use-as-is
- ☐ Suspected Unapproved

AGAINST DEPARTMENT/PROCESS

- ☐ Skid-tube
- ☐ Machining
- ☐ Thermoforming
- ☐ Large Fab
- ☐ Crosstube
- ☐ Small Fab
- ☐ Finishing
- ☐ Composite
- ☐ Water Jet
- ☐ Prod. Eng. Coor.
- ☐ Rec/Store/Packaging
- ☐ Supplier
- ☐ Engineering
- ☐ Quality
- ☐ Other
- ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

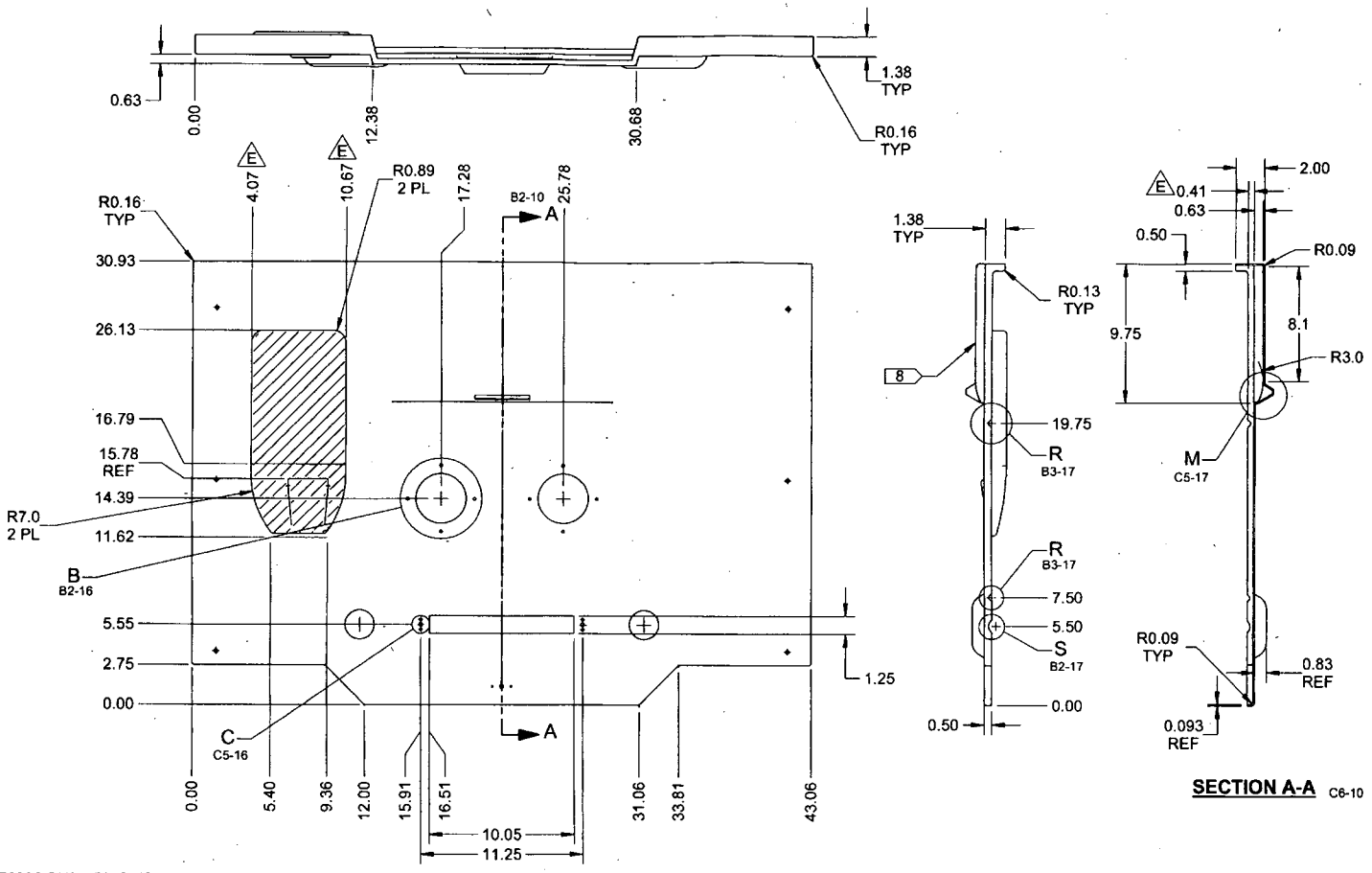
DART AEROSPACE LTD

Description:	PANEL	**Work Order:**	111328
Inspection Drawing:	D4634	Rev: ~~REV~~ E	Part Number: D4634-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.00	+/-0.030	24.00	✓		tape	SFAB-21
12.00	+/- 0.030	12.00	✓		tape	"
39.75	+/-0.030	39.75	✓		tape	"
Ø 2.020	+0.002 -0.001	2.020				SFAB-08
Ø 0.250	+0.005 -0.000	0.250	✓		vern	SFAB-08
Ø 0.129	+0.009 -0.001	0.129	✓		"	"
0.63	±0.030	0.63	✓		vern	"
3.80	± 0.030	3.83	✓		TAPE	"
14.39	+/- 0.030	14.40	✓		tape	"
17.28	+/- 0.030	17.28	✓		tape	"
25.78	+/-0.030	27.250		X		
5.55	+/-0.030	5.55	✓		tape	
15.91	+/- 0.030	15.91	✓		tape	
10.05	+/-0.030	10.05	✓		vern	
11.25	+/-0.030					
1.25	+/-0.030					
Ø 0.058	+0.004 -0.002	Ø 0.097	✓		vern	"

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
Date	Date	Date	Date



SECTION A-A C6-10

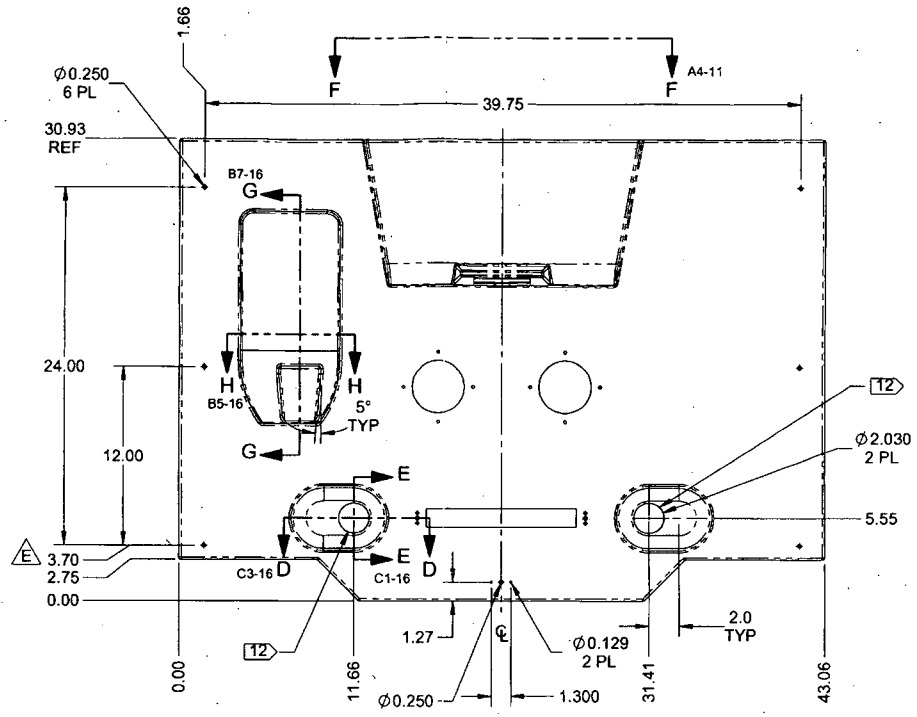
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2014 -01- 22

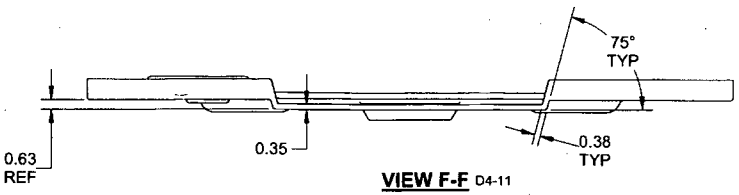
NOTES:
1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 5.65 lbs
8) TEXTURE ON THIS SIDE
9) 0.14 RADIUS NOT SHOWN FOR CLARITY
10) DRILL & TRIM D4634-1 PER TOOL DT9836
11) THERMOFORM PER QSI 022 USING DT9844 TOOL
MIN. THICKNESS AFTER FORMING:
SHADED AREA = 0.020
EDGES = 0.060
ELSEWHERE = 0.070
12) LOCATE ∅2.030 AT CENTER OF PROTRUDED SURFACE AS SHOWN

D4634-1 FWD, CENTER CEILING PANEL

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	SC	DRAWING NO. D4634 REV. E
MFG. APPR.		SHEET 10 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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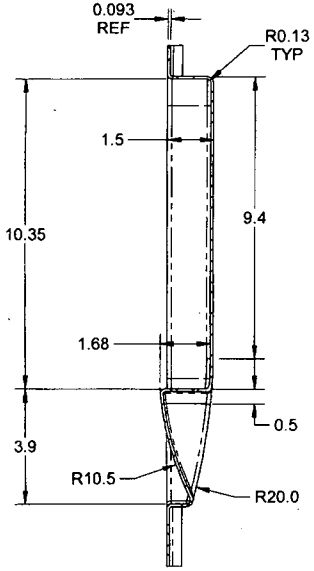
VIEW F-F D4-11

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2014 -01- 22

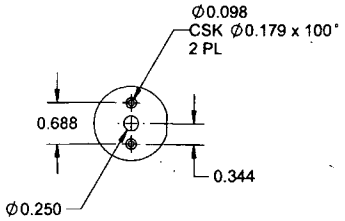
D4634-1 FWD, CENTER CEILING PANEL
AUXILIARY VIEW

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	BC	DRAWING NO. D4634 REV. E
MFG. APPR.		SHEET 11 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

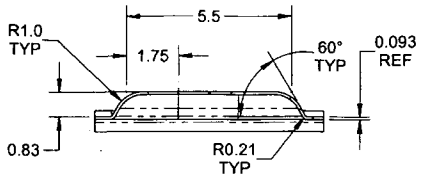
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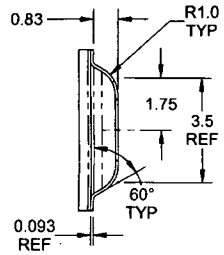
SECTION G-G C5-11
SCALE 4X



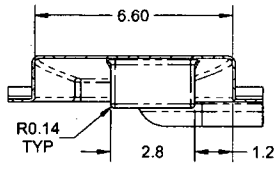
DETAIL C B7-10 B4-12 B4-14
SCALE 4X



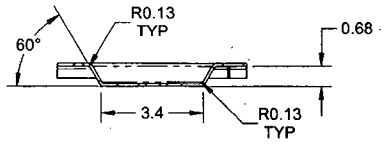
SECTION D-D B6-11 C4-13 C4-15
SCALE 2X



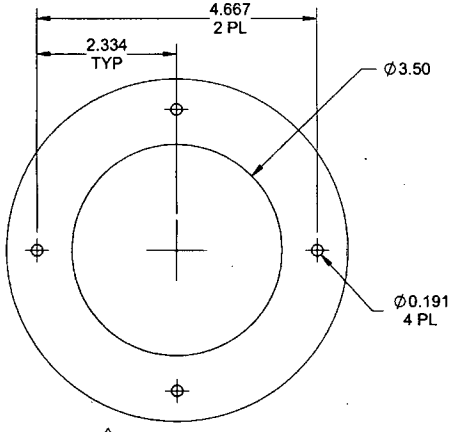
SECTION E-E B5-11 C4-13 C5-15
SCALE 4X



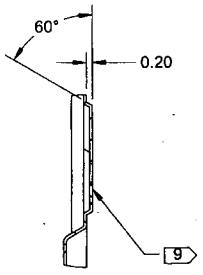
SECTION H-H C5-11
SCALE 2X



SECTION J-J B6-13
SCALE 2X



E **DETAIL B** B7-10
SCALE 4X
2 PL

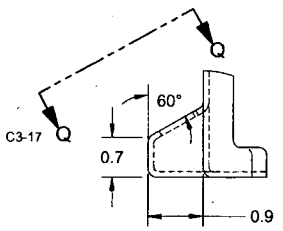


DETAIL L B2-13 C2-13 B2-14 C2-14
SCALE 4X
TYP

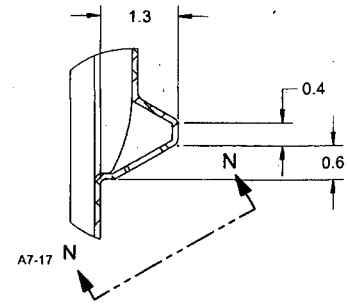
RELEASED
2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD**
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	DC	DRAWING NO. REV. E
MFG. APPR.		D4634 SHEET 16 OF 17
APPROVED		TITLE SCALE
DE APPR.		CENTER CEILING PANELS NTS
DATE	14.01.09	

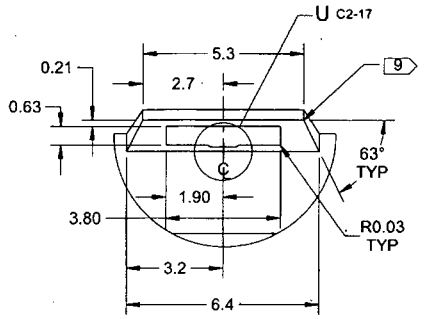
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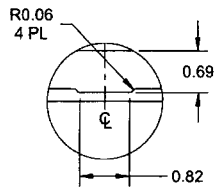
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SCALE 2X



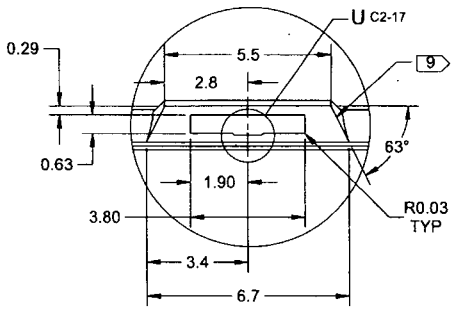
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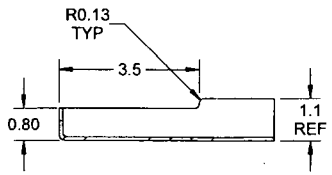
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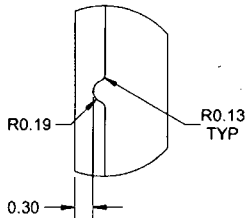
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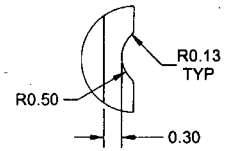
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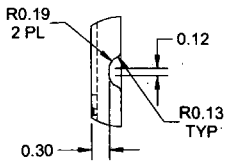
SECTION O-O B6-14
SCALE 1.3X



DETAIL R B3-10 C3-10 B2-12
SCALE 4X



DETAIL S B3-10 C2-12
SCALE 4X



DETAIL T C2-14
SCALE 4X

RELEASED
2014 -01- 22

DESIGN	RF	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED	DC	DRAWING NO. D4634 REV. E
MFG. APPR.		SHEET 17 OF 17
APPROVED		TITLE CENTER CEILING PANELS SCALE NTS
DE APPR.		
DATE	14.01.09	

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DART AEROSPACE LTD

Description:	Panel	**Work Order:**	111328
Inspection Drawing:	D4634	Rev: E	Part Number: D4634-1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
24.00	+/- 0.030	24.00	✓		tape	SFAB-21
12.00	+/- 0.030	12.00	✓		tape	"
39.75	+/- 0.031	39.75	✓		tape	"
Ø2.030	+0.012 -0.001	Ø2.010	✓		Vern	SFAB-08
Ø0.250	+0.005 -0.001	Ø0.250	✓		Vern	"
Ø0.129	+0.004 -0.001	Ø0.129	✓		Vern	"
0.63	+/- 0.030	0.63	✓		Vern	"
3.80	+/- 0.030	3.78	✓		Vern	"
14.39	+/- 0.030	14.40	✓		tape	SFAB-21
17.28	+/- 0.030	17.30	✓		tape	"
25.78	+/- 0.030	25.75	✓		tape	"
5.55	+/- 0.030	5.56	✓		tape	"
15.91	+/- 0.030	15.91	✓		tape	"
10.05	+/- 0.030	10.06	✓		tape	"
11.25	+/- 0.030	11.25	✓		Vern	SFAB-08
1.25	+/- 0.030	1.20			Vern	"
Ø0.058	+0.004 -0.001	Ø0.058	✓		Vern	"

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*):
SAD	DAS	DAS	
Date 14/02/11	16	16	
	Date 9-89	Date 9-89	Date
	14/02/11	14/02/11	